

Date: Wednesday, 6/6/2007 3:05:57 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	ADAPTER	
Job Number	32830		Part Number	D35733	
Estimate Number	12674		Drawing Number	D3573 REV.A	
P.O. Number	N/A		Project Number	N/A	
This Issue	6/6/2007	S.O. No. N/A	Drawing Revision	A	
Prsh Rev.	NC		Material	N/A	
First Issue	N/A	Type MACHINED PARTS	Due Date	6/27/2007	
Previous Run	31862		Qty:	20 Um: Each	
Written By			39 JLM		
Checked & Approved By	07-06-07				
Comment	Est Rev:A New Issue 07-01-29 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"
Comment: Qty.: 0.3066 f(s)/Unit Total : 6.1320 f(s)		.93 f.
6061-T6 Bar .50" x 2.5"		
Batch: M104366		070808
2.0	BAND SAW	BAND SAW
Comment: BAND SAW		
Cut blank 3.500" long		070808 3
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		Machined manually
Machine as per Folio FA673 and Dwg D3573		N/A 070808 3
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		070808 3
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		SG 07-08-09 3
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		BR 07-08-09 3
Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:05:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 32830

Part Number: D35733

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



M104846



(3K)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-k 07/08/09

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



P 7/8/10 (3)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 7/8/10

(3)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

D 7/8/10

Job Completion



C 7/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

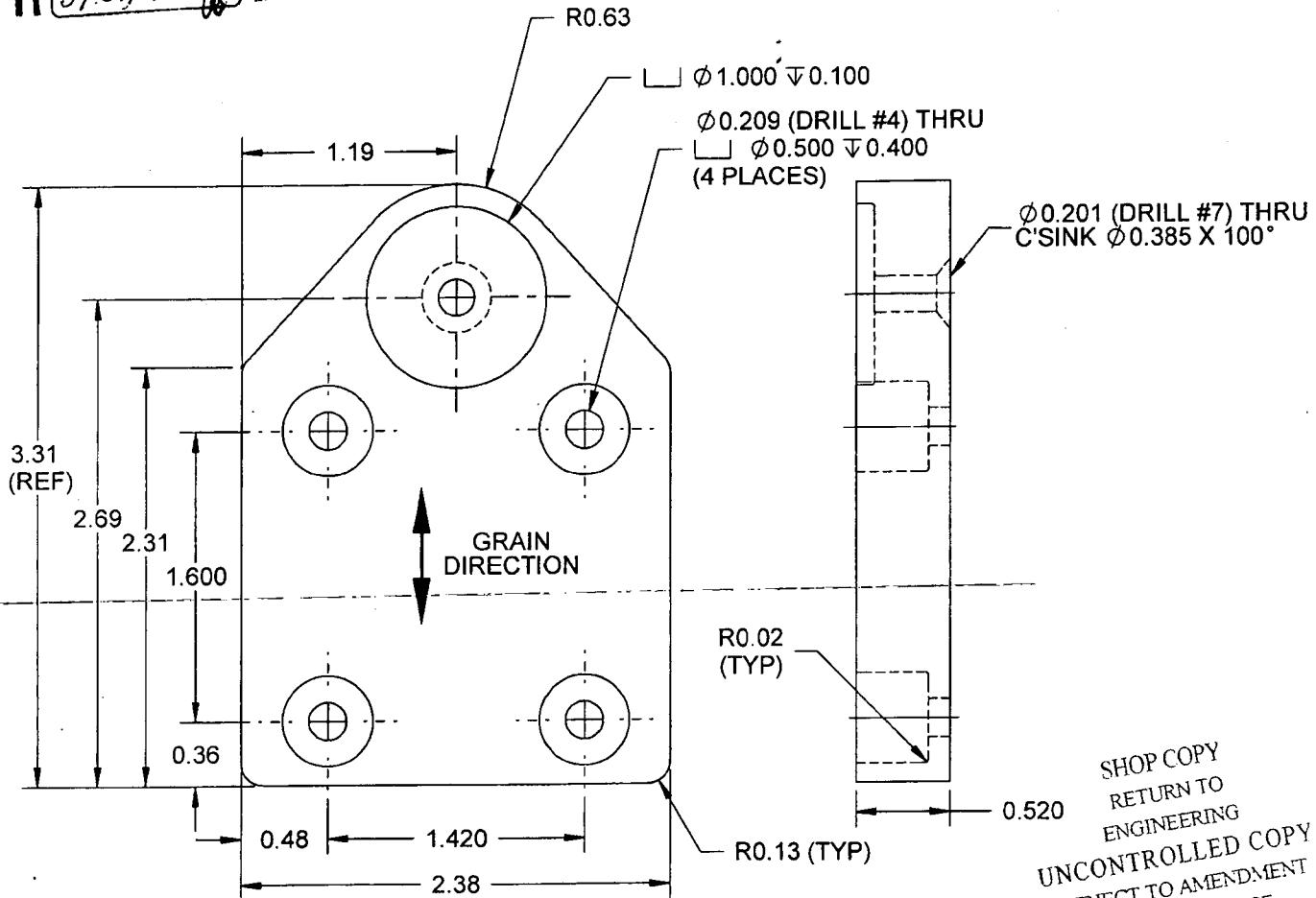
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

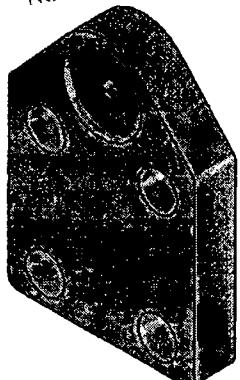
NOTE: Date & initial all entries

DART

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CHECKED <i>PH</i>	APPROVED <i>AT</i>	DRAWING NO. D3573	REV. A	SHEET 1 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE	1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE		

RELEASED
07-03-22**D3573-1 ADAPTER**

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WORK ORDER
NO. *32830*

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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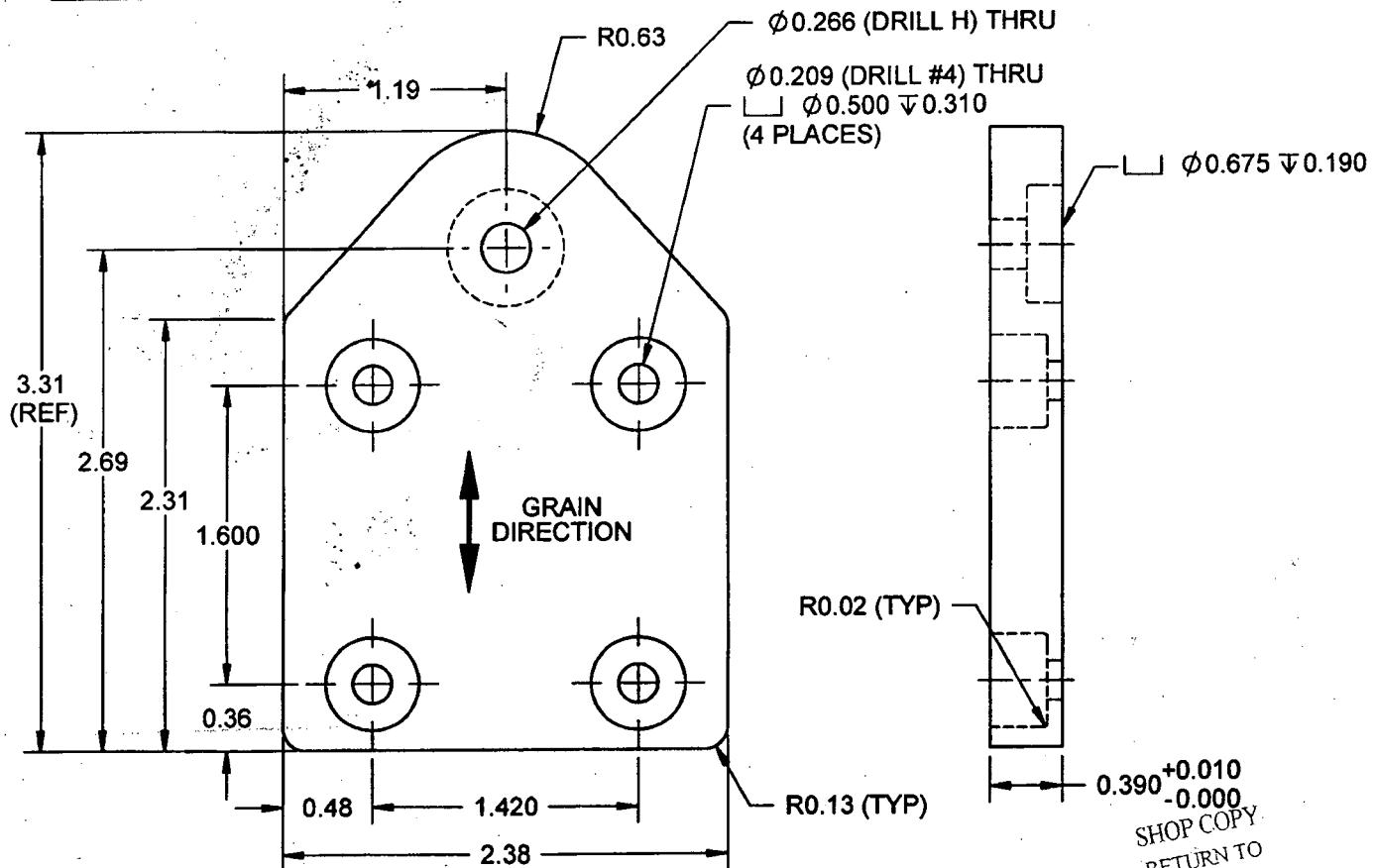
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CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3573	REV. A	SHEET 2 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1	

RELEASED
07-04-02 ~~11~~

07.04.02 ~~ff~~



D3573-3 ADAPTER

0.390 ^{+0.010}
-0.000
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NO. 32830

NOTES:

NOTE:

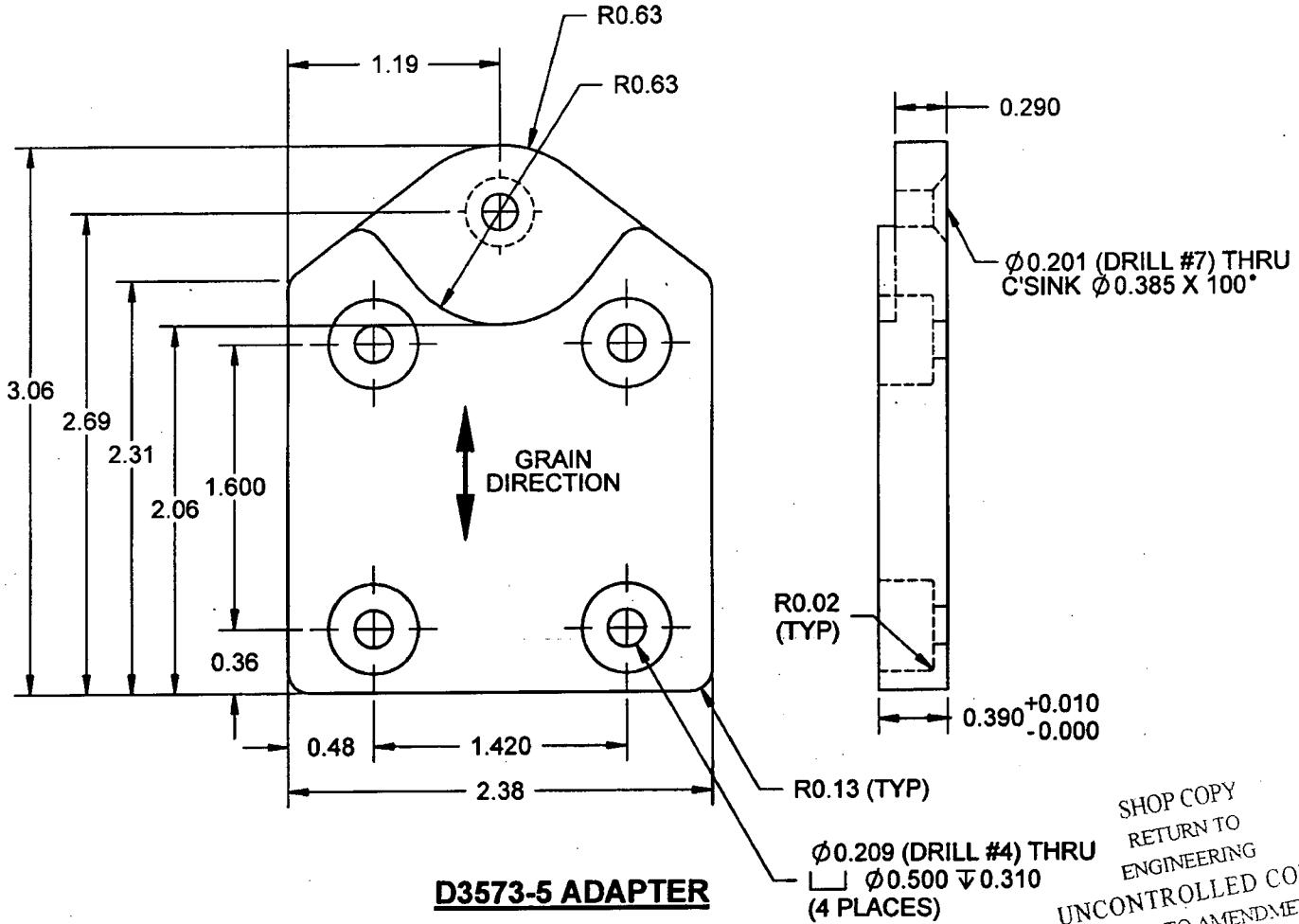
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
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DATE 07.02.19	TITLE ADAPTER	REV. A SHEET 3 OF 4 SCALE 1:1

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07.04.02

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WORK ORDER
NO. *32830*

NOTES:

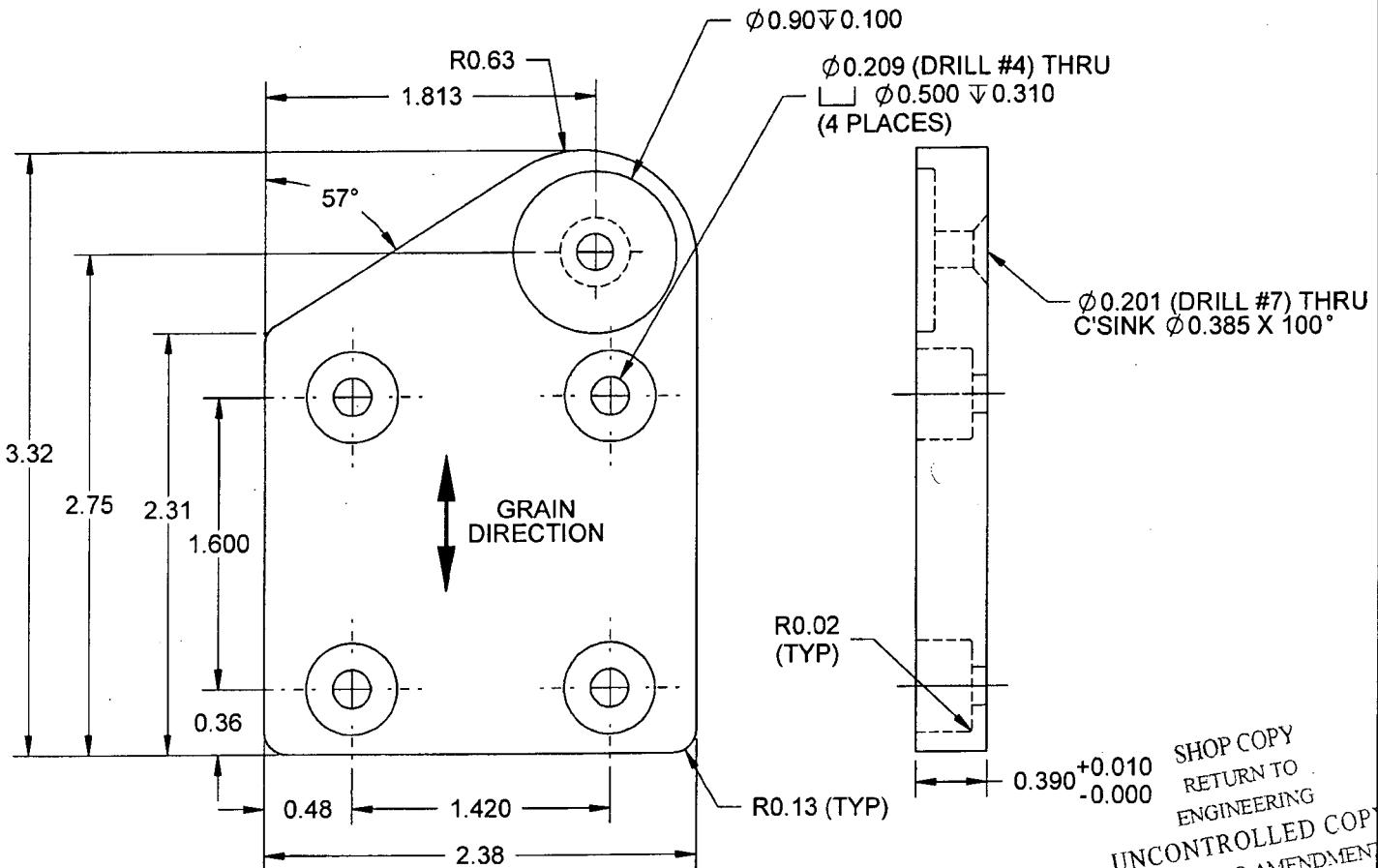
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PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
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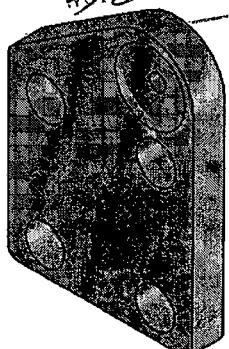
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07.04.02 9/1



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)



NOTES:

NOTE:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
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DART AEROSPACE LTD

Work Order: 32830

Description: Adapter

Part Number: D3573-3

Inspection Dwg: D3573 Rev: 4

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	$\pm .030$	3.314	—			
2.69	$\pm .030$	2.691	—			
2.31	$\pm .030$	2.310	—			
1.600	$\pm .030$	1.599	—			
.36	$\pm .030$.359	—			
1.19	$\pm .030$	1.186	—			
$\emptyset 1.266$	$\pm .005$.268	—			
$\emptyset .209$	$\pm .005$.210	—			
.500 .310						
.500	$\pm .010$.505	—			
.310	$\pm .010$.308	—			
.675	$\pm .010$.672	—			
.190	$\pm .010$.189	—			
.48	$\pm .030$.481	—			
1.420	$\pm .010$	1.418	—			
2.38	$\pm .030$	2.382	—			
.390	$\pm .010$.396	✓			
R. 63	$\pm .03$.63	—			

Measured by: 

Audited by: 

Prototype Approval:

Date: 070808

Date: 07.07.2019

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	